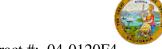
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-004776 Address: 333 Burma Road **Date Inspected:** 04-Nov-2008

City: Oakland, CA 94607

Project Name: SAS Superstructure **OSM Arrival Time:** 1400 **OSM Departure Time:** 2200 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island, Shang

CWI Name: CWI Present: Yes N/A No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes N/A **Delayed / Cancelled:** No

Bridge No: 34-0006 **Component:** Deck panel

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) representative was present for observations relative to fabrication performed by Zhenhua Port Machinery Company (ZPMC) for the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Changxing Island, in Shanghai, China. While on site the QA Inspector noted the following:

Deck Panel DP325-002

1. The QA Inspector performed Ultrasonic Testing (UT) on the Partial Joint Penetration (PJP) welds made between the U-ribs (four ribs, two welds per rib eight total welds) and flat plate members of the assembly deck panel identified as DP325-002. The QA Inspector performed the ultrasonic testing using the gate to gate method on the tack weld areas only a total of 208 tack welds were made on the eight welds. The QA Inspector performed the testing on the weld number one through eight. The QA Inspector observed several linear indications that appeared to be suspected planar discontinuities located at random locations on the welds and the indications were marked on the steel for Phased-Array Ultrasonic Testing (PAUT) investigation that will be performed at a later time. The QA Inspector used the ZPMC ultrasonic testing procedure identified as "UT 04-012024 PJP Rib Weld", Ultrasonic Testing for the Detection of Suspected Planar Discontinuities (Cracks) in PJP Welds for the evaluation of observed indications. The QA Inspector completed the testing on these welds at this location on this date. The QA Inspector recorded the indication's location observed on the QA Inspector's log and document is available for review as requested. The QA Inspector notified Task Leader Albert Carreon of indications observed and the status of completed testing.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Summary of Conversations:

None of major significance.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann, (1500) 129-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Medina,Ricardo	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer